Page 1

Thursday, November 25, 2010 4:01:03 PM Item ID: D4298-013 Accept Setup Start Revision ID: PRELIM Stop Hinge Item Name: **Start Date:** 11/25/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 12/3/2010 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date: 10-11-26 Tooling: Approvals: **Process Plan:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Qty **Run Hours** Code **Qty** Number Stamp Draw Nbr **Revision Nbr** D4298 PA1 100 Cut blanks as per folio 0.00 0.00 andidatog Bandsaw Memo Jeaspa Bandsaw 110 0.00 me iolislog HAAS 1 0.00 Memo HAAS CNC vertical machine #1 0.00 ml 10/12/09 120 QC2- Inspect parts off machine FAI/FAIB QC 0.00 Memo Quality Control

Dart A	\erosp	ace	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	PAR #	я •	Fault Category:	NCR: Yes N	o <b>DQA</b> :	Date:
	Resolution:		Disposition:	QA: N/C Clos	sed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE STEP		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
		Section A	Chief Eng Chief Eng Da		Sign & Date	Section C	Chief Eng	QC Inspector			
ioli2108	1/0	2 parts scrap hale are too big, the other one the hale are too small R.C. miss info on the dwg Prelim Process, 3rd publiclesism		Dersp andreplace Qty2 Balch # M 116135	onl						
		R.C. miss info on the dwg	pesion				distun	10.12.02			
		prelim process, 3rd portyclesign			·						
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Work Orde Thursday, Noven													Page 2	
Revision ID:	D4298-013 PRELIM Hinge		· :		Accept					Setup	Start Stop			
Start Date: Required Date: Reference:	11/25/2010 12/3/2010	Start Qty: 1.00 Req'd Qty: 1.00				Cust Item I Customer:	D:							
Approvals:		n:			Tooling: SPC (Y/N):		ate:	-		Run	Start Stop			
Sequence ID/ Work Center ID  130 QC Quality Control	<b>)</b>	Operation Description QC8- Inspect parts - se	econd check	vern	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp	
140 HandFinish Hand Finishing		Chemical Conversion	Coat per QS1005	4.1	0.00 HJ	10/12/10			<u>y</u> _	<u> </u>	<b>4</b>			
150 Powdercoat Powder Coating	•	Black Sandtex(Ref:4.3 MID538 Memo	5.5.7) per QS1005 STAP OUEN FIÑIS6	T. 8" 1T.86	0.00 40 5 ·						_6	1/0-	VD-V4.	

Do not powder cont in the grownous hole. 10.12.09

Dart Aerospa	ace Ltd
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W/O:		1,	WO	RK ORDER CHANG	ES				э
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:		_ Date: _	
		esolution:							
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC	ļ	Corrective Action Section		Verification			Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C ———	Chief Eng	QC Inspector
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Item ID:

D4298-013

**Revision ID:** 

**PRELIM** 

Thursday, November 25, 2010 4:01:03 PM

Item Name:

**Start Date:** 

11/25/2010

Hinge

Start Qty: 1.00 Required Date: 12/3/2010

**Req'd Qty:** 1.00

Accept



Setup Start

Stop



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

A	nn	rov	/ale	8:
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Process Plan:

QC:

Date:

Date: \_\_\_\_\_ SPC (Y/N):

**Tooling:** 

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

160

**Quality Control** 

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

10/12/14

Tool # Plan Code

Reject Accept Qty Qty

Reject Number Stamp

Insp.

170

Small Fab

Small Fab

Memo

assemble as per dwg

0.00

0.00

0.00

\* =>m-/ w/12

180

QC5- Inspect part completeness to step on W/O

0.00

E 10.12.14

QC

Quality Control

Memo

0.00

# **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANG	ES				ì	
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		PAR #:	Fault Cated	jory:	_ NCR: Yes	No DQ	\: Date:			
	R	esolution:	Disposition	1:	_ QA: N/C CI	osed:		Date:		
NCR:			WORK ORDI	R NON-CONFORMA	NCE (NCF	<b>R</b> )				
DATE	STEP	Description of NC	<u></u>	Corrective Action Secti		Verific		Approval	Approval	
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector	
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Thursday, November 25, 2010 4:01:03 PM



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Item ID:

D4298-013

**PRELIM** 

**Revision ID:** Item Name:

Hinge

**Start Date:** 11/25/2010

Start Qty: 1.00

Accept



Setup Start

Stop



**Required Date: 12/3/2010** 

Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Reference:

QC:

Process Plan:

Date:\_\_\_\_\_

Date: **Tooling:** 

SPC (Y/N):

Date:

Tool ID

Date:

Run

Accept

Qty

Start



Stop

Reject

**Qty** 

Sequence ID/ Work Center ID

190



Packaging

Operation **Description** 

Identify as per dwg & Stock Location: GA

104/46

Set Up/ **Run Hours** 

0.00

0.00

10/12/14

Tool # Plan

Code

Number

Reject

Insp. Stamp

Packaging

200

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

Mt 10-12-14

OSITIVE RECALL

EFFECTIVE 10-11-29 AUTH

RELEASED \_\_\_\_\_ DATE



## **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES							
DATE STE		1	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1									
Part No	:PAR		PAR #: Fault Category:		NC	NCR: Yes No D			/Date: _	10:12:17
	F	Resolution:		Disposition:			closed:		Date: _	
		T		WORK ORDER NON	CONTORNANCE	- /NIC	D)			

NCR:		We	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval Chief Eng	Approval QC Inspector	
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C			
	·	BRA. duyter D. 150 9.25 & port is \$172		See -014 update duy			Posiun	Inva u
			Losur		-		7931012	10:12.17
				•				:

Thursday, November 25, 2010 4:01:07 PM

Work Order ID: 64156

D4298-013

Parent Item Name: Hinge



Start Date. 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

Parent Item:

IPP rev A 11.10.25 new issue EC verified by: DD

	Replacement tem ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.00		Purchased	No				f	40.0000	0.25	0.263158			
6061-T6 Bar -750 X T.00										) 10	12/07		
MG061T6 B 1.3	95'×1,25	5		Location MAT02	12567	Loc (	40	Loc Code	_	.27	ans	10/12	/08
MS27980-1B		Purchased	No	ı	1116135 116351	XIII	Each	0.0000	1	1	olis	·	
MS27980-6B		Purchased	No	M 11	6290		Each	0.0000	. 1	1 Sa	10/12	/ U4	

Socket, Snap Fastener

MILLO

# **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHAN	GES					2
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			
Part No		PAR #:	Fault Categ	ory:	NC	R: Yes	No <b>DQ</b>	A:	Date:	
Resolution:		Disposition:			N/C C	Date: _	•			
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCF	₹)			
	T	Description of NC	Corrective Action Section			VARITICATION			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	& Sect	ion C	Chief Eng	QC Inspector
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										f
						-				

DART AEROSPACE LTD	Work Order:	64156
Description: HINGE	Part Number:	D4298-013
Inspection Dwg: DY298 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
D.090	±.03b	. 089			Vern	MC-7
. 8.3	±-030	.830			(\	
2,88	±.030	2.880			1(	(C
.12	± 030	.120.		****	1\	10
.78	±.03p	.777			((	٦.
Ø. 406	+ . 605 poo	8.407			**	7,
Ø.53	± .63b	0.530				У
. 61	±. 636	-610			(/	١,
- 1)	- 030	.167			\1	4
			`			
P. Company						
			1			
Measured by:	9m)	Audited by:			Preliminary A	

Measured by:	and	Audited by:		Preliminary Approval:	
Date:	10/12/09	Date:	10.12.09	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15





